

**Work Order ID 87015**

Monday, July 09, 2012 3:51:17 PM

Item ID: D350-636-013

Accept

**\*87015\***

Revision ID:

Item Name: Skidtube LH

Start Date: 7/10/2012 Start Qty: 1.00 **\*1\***Required Date: 7/24/2012 Req'd Qty: 1.00 **\*1\***

Reference:

Approvals: Process Plan: MLJDate: 12/07/10 Tooling:

Cust Item ID:

QC:

Date:

SPC (Y/N):

Date:

Date:

Setup Start **\*NS1\***Stop **\*NS2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

IIN-D350-636

I

100

**\*100\***

DC

Document Control

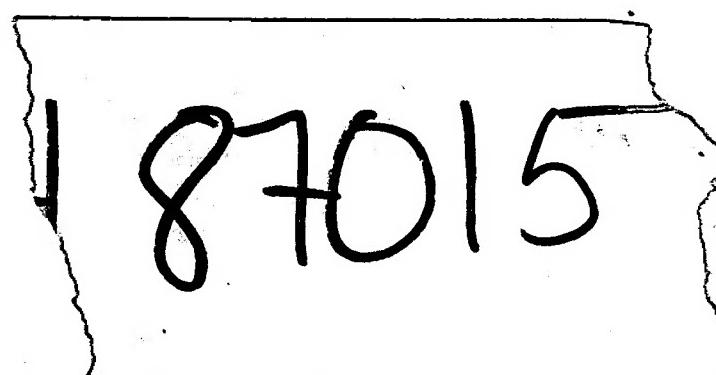
DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-013 CHG 006

DAS  
 12-07-26  
 rluwz7

*for MLJ 12-7-26*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 87015**

Monday, July 09, 2012 3:51:17 PM

**\*87015\***

Page 2

**Item ID:** D350-636-013**Accept****\*N900040100\*****Setup****Start \*NS1\*****Revision ID:****Item Name:** Skidtube LH**Stop****\*NS2\*****Start Date:** 7/10/2012 **Start Qty:** 1.00 **\*1\*****Cust Item ID:****Required Date:** 7/24/2012 **Req'd Qty:** 1.00 **\*1\*****Customer:****Reference:**

<b>Approvals:</b>	<b>Process Plan:</b>	<b>Date:</b>	<b>Tooling:</b>	<b>Date:</b>	<b>Run</b>	<b>Start</b>	<b>*NR1*</b>
						<b>Stop</b>	<b>*NR2*</b>
	<b>QC:</b>	<b>Date:</b>	<b>SPC (Y/N):</b>	<b>Date:</b>			

<b>Sequence ID/ Work Center ID</b>	<b>Operation Description</b>	<b>Set Up/ Run Hours</b>	<b>Tool ID</b>	<b>Tool #</b>	<b>Plan Code</b>	<b>Accept Qty</b>	<b>Reject Qty</b>	<b>Reject Number</b>	<b>Insp. Stamp</b>
110		0.00							
<b>*110*</b>	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	I- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-3 details).Drill using drill Jig DT8150 & DT8864A for first side only DT8864B for second side (detail B)								
	7- Clecko DT8864B on second side of tube and drill pilot holes for detail B. <b>***SECOND SIDE***</b>								
	8- Open up holes for SECTION AW-AW to 0.375" (2 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail T to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side)								

BB 12/07/16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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NOTE: Date &amp; initial all entries

**Work Order ID 87015**

Monday, July 09, 2012 3:51:17 PM

Item ID: D350-636-013

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**\*87015\***

Revision ID:

Item Name: Skidtube LH

Start Date: 7/10/2012 Start Qty: 1.00 **\*1\***Required Date: 7/24/2012 Req'd Qty: 1.00 **\*1\***

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004A/R Aluminum Rod batch: m122130

12-Grind welds flush as per Dwg D2750

120

**\*120\***

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00



7/07/12

Memo

130

**\*130\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00



7/07/12

Memo

W/O:		WORK ORDER CHANGES					
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**Work Order ID 87015**

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Item ID: D350-636-013

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***Start Date: 7/10/2012 Start Qty: 1.00 **\*1\***Required Date: 7/24/2012 Req'd Qty: 1.00 **\*1\***

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center ID

140

**\*140\***

HandFinish

Hand Finishing

Operation  
Description

Chemical Conversion Coat per QSI005 4.1

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

**\*150\***

QC

Quality Control

QC7-Inspect Chemical Conversion Coat

0.00

Memo

0.00

1 7/12/18

600

DP 12-7-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Item ID: D350-636-013

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Revision ID:

Item Name: Skidtube LH

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\*****\*N900040100\***

Setup

Start

**\*NS1\***

Stop

**\*NS2\***

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

**\*160\***

Skidtubes

Skidtubes

0.00

Skidtubes

Memo

0.00

1-Open up holes section AW-AW 0.500" (4 per side) as per dwg D2750

3-Open up holes of Detail T and ground handling to 0.625" (total of 8 holes per side Detail AV-AV) as per dwg D2750.

4-Chamfer holes of section AW-AW, AV-AV, T and ground handling. (welding instructions on sheet 10)

5-Deburr and blow out all chips from inside of tube. Prepare tube for welding, remove alodine as required.

6-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 12230  
exp. date: 13-3-14 - DC 12/07/187- Weld spacers D3490-1, D3490-5 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 10)A/R Aluminum Rod batch: M12230

8-Grind welds flush as per Dwg D2750

9-Spot face ground handling holes (total of 4 places per side) as per dwg D2750

10-Deburr holes

DC 12/07/18B 12/07/18B 12/07/19B 12/07/23

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Item ID: D350-636-013

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC10- Inspect visual per QSI004- ground welds

0.00

DAS  
16  
9-89

7/10/12

**\*170\***

QC

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

DAS  
16  
9-89

7/10/12

**\*180\***

QC

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

**\*190\***

HandFinish

Hand Finishing

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.


  
 12/7/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Item ID: D350-636-013

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Revision ID:

Item Name: Skidtube LH

Start Date: 7/10/2012 Start Qty: 1.00 **\*1\***Required Date: 7/24/2012 Req'd Qty: 1.00 **\*1\***

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center ID

200

**\*200\***

Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

MX

12/07/24

8:50 0.00  
320°F  
9:20

210

**\*210\***

QC

Quality Control

QC3- Inspect Part Finish

0.00

1 LH Q 12/07/25

Memo

Inspect for foreign object per QSI 024

220

**\*220\***

HandFinish

HandFinishing

0.00

1 LH Q 12/07/25

Memo

1-Install inserts as per dwg D2750

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

**Work Order ID 87015**

Monday, July 09, 2012 3:51:17 PM

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Item ID: D350-636-013

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

**\*230\***

HandFinish

Hand Finishing

HandFinishing

0.00

Memo

0.00

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 122130EXP DATE: 19/074-assemble o'ring to plug as per dwg D3492 and apply o'ring lube  
A/R 55-o'ring lube batch: 40 3495-Coat all exposed fasteners with "LPS Procyon" batch: 114 556

240

**\*240\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

DAS  
16  
9-89

7/9/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

**Work Order ID 87015**

Monday, July 09, 2012 3:51:17 PM

**\*87015\***

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Item ID: D350-636-013

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop

**\*NS2\***

Start Date: 7/10/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 7/24/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
Description

280

QC21- Final Inspection - Work Order Release

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

**\*280\***

QC

Quality Control

Memo

0.00

12/7/2012

MCT 12/07/2012

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 1  
TJ

Work Order ID: 87015

Parent Item: D350-636-013

Start Date: 7/10/2012

Required Date: 7/24/2012

Parent Item Name: Skidtube LH

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H02.09.25Rearranged procedure steps KJ

IPP rev I 06.03.30 Per rev. D dwg EC

IPP Rev:J 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC

IPP Rev:K 08-09-23 revF as per dwg DD verified by:ec IPP Rev:L 10.06.22 revise seq110

DD verf:EC IPP Rev:M 10.10.01 as per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
ALS4-1032-225 Insert		Purchased	No			230	Each	2,888.0000	38	38	38	(28)	12/07/25

Location	Loc Qty	Loc Code
FP-B	2445	
122290 ✓	2445	
ST281	420	
108696	146	
110768	62	
118386	55	
118966	68	
121269	89	
ST282	23	
120410	10	
120451	13	

W/O:		WORK ORDER CHANGES					
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Work Order ID: 87015

Parent Item: D350-636-013

Start Date: 7/10/2012

Required Date: 7/24/2012

Parent Item Name: Skidtube LH

Start Qty: 1.00

Required Qty: 1.00

AN3C5A | Purchased No 230 Each 1,611.0000 34 34  
Bolt 34 12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	7	
115835	7	
ST350	1604	
116419	28	
117343	13	
117764	7	
117872	2	
119749	23	
120423	28	
121255✓	469	
121444	34	
121708	500	
122141	500	

AN3C6A | Purchased No 230 Each 285.0000 4 4 12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	1	
111982	1	
ST351	284	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693✓	118	
121682✓	74	

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Shop Packet Print

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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**Work Order ID:** 87015

**Parent Item:** D350-636-013

**Parent Item Name:** Skidtube LH

**Start Date:** 7/10/2012

**Required Date:** 7/24/2012

**Start Qty:** 1.00

**Required Qty:** 1.00

AN6C44A BOLT	Purchased	No	230	Each	104.0000	4	4	⑧	12/07/25
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<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
103964	2	
ST343	102	
121013	11	
121440	41	
122204✓	50	

AN8C21A BOLT	Purchased	No	250	Each	77.0000	2	2	⑧	12/07/25
-----------------	-----------	----	-----	------	---------	---	---	---	----------

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST343	77	
118758	3	
121275	24	
122204✓	50	

AN8C35A BOLT	Purchased	No	230	Each	61.0000	1	1	⑧	12/07/25
-----------------	-----------	----	-----	------	---------	---	---	---	----------

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	60	
115960	1	
118286	9	
121275✓	50	
ST346	1	
114442	0	
115188	0	
115960	1	

AN960C10L washer	NAS1149C0332R✓	Purchased	No	230	Each	21.0000	38	38	⑧	12/07/25
---------------------	----------------	-----------	----	-----	------	---------	----	----	---	----------

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	122063✓	
107534	21	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 4

Work Order ID: 87015

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Extrusion Bent

Manufactured

No

110

Each

33.0000

1

1

1  
A

B 12/07/16

Location	Loc Qty	Loc Code
----------	---------	----------

LG	33	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
83305	1	
86330	17	

D2739

350 I Beam

Manufactured

No

160

Each

14.0000

1

De 12/07/18

①

Location	Loc Qty	Loc Code
----------	---------	----------

LG	14	
72155	1	
81508	1	
83448	2	
83548	1	
85486	5	
86615	4	

D2741

Blade, 350 Skidtube

Manufactured

No

250

Each

34.0000

1

Sp 12-7-26

h

Location	Loc Qty	Loc Code
----------	---------	----------

ST	-10	
ST466	44	
71856	1	
83135	33	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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**Work Order ID:** 87015

**Parent Item:** D350-636-013

**Start Date:** 7/10/2012

**Required Date:** 7/24/2012

**Parent Item Name:** Skidtube LH

**Start Qty:** 1.00

**Required Qty:** 1.00

D2743

Crossbolt Spacer

Manufactured

No

220

Each

152.0000

8

8

BL12/07/19  
885459 x3

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	78	
81965	23	
83262	55	
LG001	74	
67766	4	
68251	3	
73403	64	
74445	1	
79517	2	

D2744

Cap

Manufactured

No

160

Each

60.0000

1

1

BL12/07/14

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	60	
62715	1	
83412	21	
85506	38	

D2745

Bushing

Manufactured

No

230

Each

258.0000

8

8

8 12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	206	
79518	6	
85416 ✓	200	
FP001	52	
69529	1	
76142	1	
83260	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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**Work Order ID:** 87015

**Parent Item:** D350-636-013

**Parent Item Name:** Skidtube LH

**Start Date:** 7/10/2012

**Required Date:** 7/24/2012

**Start Qty:** 1.00

**Required Qty:** 1.00

D3488-041

Blade Fitting Assembly, LH

Manufactured

No

230

Each

29.0000

1

1

(2)

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	12	
85807 ✓	12	
FP002	17	
83407	10	
85733	7	

D3490-1

Cross Bolt Spacer

Manufactured

No

160

Each

79.0000

4

4

BE12/07/19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	68	
81976	2	
85419	66	
LG001	11	
62450	2	
74875	4	
77042	3	
83269	2	

D3490-5

Cross Bolt Spacer

Manufactured

No

160

Each

31.0000

4

4

BE12/07/19

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	31	
83373	31	

D3492-1

Plug

Manufactured

No

230

Each

205.0000

8

8

(2)

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	198	
69531	8	
74444	2	
76235	4	
83259 ✓	184	
FP-A	7	
83098	7	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 87015

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3492-5

Manufactured

No

230

Each

135.0000

8

8

12/07/25

Plug

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	fpa	135	
	83100 ✓	34	
	83530	101	

D3493-1

Washer

Manufactured

No

110

Each

97.0000

2

2

SP H

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	ST050	97	
	77573	1	
	82023	2	
	83097	94	

D3535-25

Wearshoe

Manufactured

No

230

Each

32.0000

1

1

12/07/25

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP001	32	
	62233	1	
	81357	1	
	83387	17	
	83899 ✓	13	

D3536-25

Gasket

Manufactured

No

230

Each

22.0000

1

1

12/07/25

	<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
	FP	22	
	83391	6	
	83900 ✓	16	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 87015

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

D3537-1

Wearpad

Manufactured

No

230

Each

112.0000

3

3

3

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	112	
81362	3	
83254	1	
83255	3	
83256	20	
85457 ✓	37	
85458	48	

D3631-1

Washer

Manufactured

No

230

Each

283.0000

8

8

8

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	268	
81874	2	
83588 ✓	266	
ST072	15	
68062	2	
75548	13	

D3791-1

Wearplate

Manufactured

No

230

Each

26.0000

1

1

1

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	26	
62239	2	
83392 ✓	12	
83902	12	

D3793-1

Wearshoe

Manufactured

No

230

Each

26.0000

1

1

1

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	26	
82171	2	
83393	11	
83903 ✓	13	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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**Work Order ID:** 87015

**Parent Item:** D350-636-013

**Parent Item Name:** Skidtube LH

**Start Date:** 7/10/2012

**Required Date:** 7/24/2012

**Start Qty:** 1.00

**Required Qty:** 1.00

D3793-3  
Wearshoe

Manufactured

No

230

Each

28.0000

1

1

(SP)

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	28	
83394 ✓	16	
83901	12	

D3794-1  
Gasket

Manufactured

No

230

Each

24.0000

1

1

(SP)

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	4	
82167	4	
FP002	20	
83395 ✓	20	

D3794-3  
Gasket

Manufactured

No

230

Each

45.0000

1

1

(SP)

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	19	
83396 ✓	19	
FP002	26	
74530	2	
86243	24	

MS21043-6  
NUT

Purchased

No

230

Each

586.0000

4

4

(SP)

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
103693	20	
ST301	566	
117887	2	
118384 ✓	64	
120308	500	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 10

Work Order ID: 87015

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

NUT

Purchased

No

230

Each

94.0000

1

1

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

304	39	
121185	22	
121349	17	

FP002	1	
115884	1	

ST303	4	
115884	0	
118077	1	
119309	2	
119638	1	

ST321	50	
122141	50	

MS21083C8

NUT

Purchased

No

250

Each

94.0000

2

83 12-7-26

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

304	39	
121185	22	
121349	17	

FP002	1	
115884	1	

ST303	4	
115884	0	
118077	1	
119309	2	
119638	1	

ST321	50	
122141	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 87015

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

250.0000

1

120

12/07/25

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	250	
114915 ✓	250	

NAS1149D0863J

Purchased

No

250

Each

221.0000

2

SP

J

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	221	
118078	34	
119307	1	
120308	86	
121556	100	

NAS1515H3L

Purchased

No

230

Each

311.0000

4

4 SP

12/07/25

WASHER

X

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	113362 ✓	40
	102472	40
ST277	271	
	118686	3
	120360	11
	121556	57
	122151	200

NAS1611-005

Purchased

No

230

Each

140.0000

8

8 SP

12/07/25

O-RING

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	140	
106099	18	
114220 ✓	46	
119438	36	
121415	40	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 12

Work Order ID: 87015

Parent Item: D350-636-013

Parent Item Name: Skidtube LH

Start Date: 7/10/2012

Required Date: 7/24/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

416.0000

8

8

DP

12/07/25

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	416	
110915	14	
117460	8	
118077	1	
118612	3	
119438	47	
121259	2	
121584	2	
121723	39	
122151✓	300	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	CPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
F	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
	34	34	34	AN3C5A	BOLT
	4	4	4	AN3C6A	BOLT
	4	4	4	AN5C44A	BOLT
	1	1	1	AN8C35A	BOLT
F	38	38	38	AN960C10L	WASHER
	1	1	1	AN960C816L	WASHER
	4	4	4	MS21043-6	NUT
	1	1	1	MS21083C8	NUT
	4	4	4	NAS1515H3L	WASHER

**GENERAL NOTES:**

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
  - 2) FINISH:
    - ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
    - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
    - BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
  - 8) WELD PER DART QSI 004
  - 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
  - 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
    - MINIMUM YIELD TENSILE STRENGTH = 35 KSI
    - MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
  - 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
  - 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL 
  - 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

F	INCORPORATE DS1 9413, QTY (3) D3537-1, WAS QTY (5) (ZN C8-1) D3486-041/042, D3535-13/35 (ZN C8-1); D3784-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3486-041/042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11), ADD NOTE (2 AND 13 ZN A6-1), REASON REF. NCR 08-043	PH	08 07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES. ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1; REMOVE QTY (3) NAS1515HSL; REMOVE QTY (10) NAS1515HSL; REMOVE D2741, QTY (2) AN900C816, REMOVE QTY (2) MS21083C8	CB	07 05.17
D	ADD HOLES AND SCREWS FOR APICAL FLOATS, INCORPORATE DEO 9133/9157	PH	06 01.05
C	ADD D2750-3/D2750-4, INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24594-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	<i>RJ</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>RJ</i>	PORT HADLOCK, WA	
CHECKED	<i>RJ</i>	DRAWING NO. <b>D2750</b> REV F	
MFG. APPR.	<i>APC</i>	SHEET 1 OF 11	
APPROVED	<i>LW</i>	TITLE	
DE APPR.	<i>LW</i>	350 SKIDTUBE ASSEMBLY SCALE	
DATE	08.07.16	NITS	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

6

5

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1

D

D

C

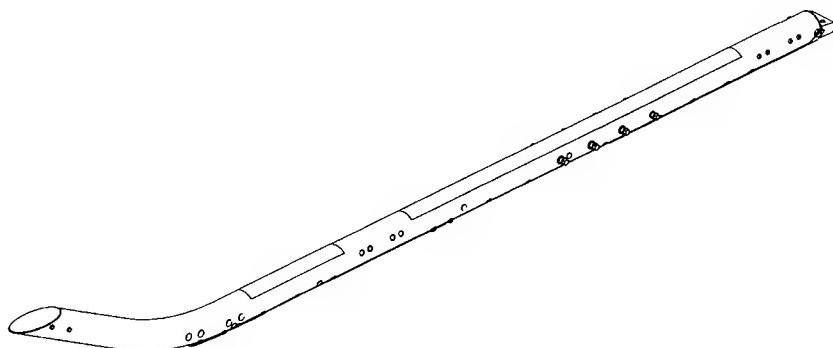
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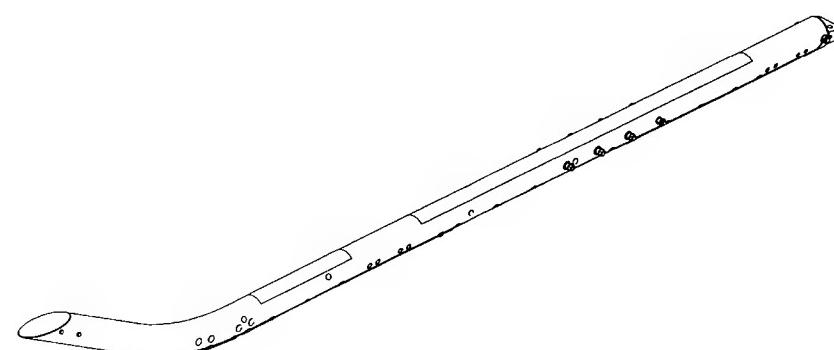
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A

A



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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08-07-16

DESIGN	<i>PJ</i>	<b>DART AEROSPACE USA, INC.</b>			
DRAWN	<i>AJ</i>	PORT HADLOCK, WA			
CHECKED	<i>BL</i>	DRAWING NO			
MFG. APPR	<i>NA</i>	REV. F			
APPROVED	<i>MJ</i>	D2750			
DE APPR	<i>NA</i>	SHEET 2 OF 11			
DATE	08.07.16	TITLE	SCALE		
		350 SKIDTUBE ASSEMBLY			
NTS					
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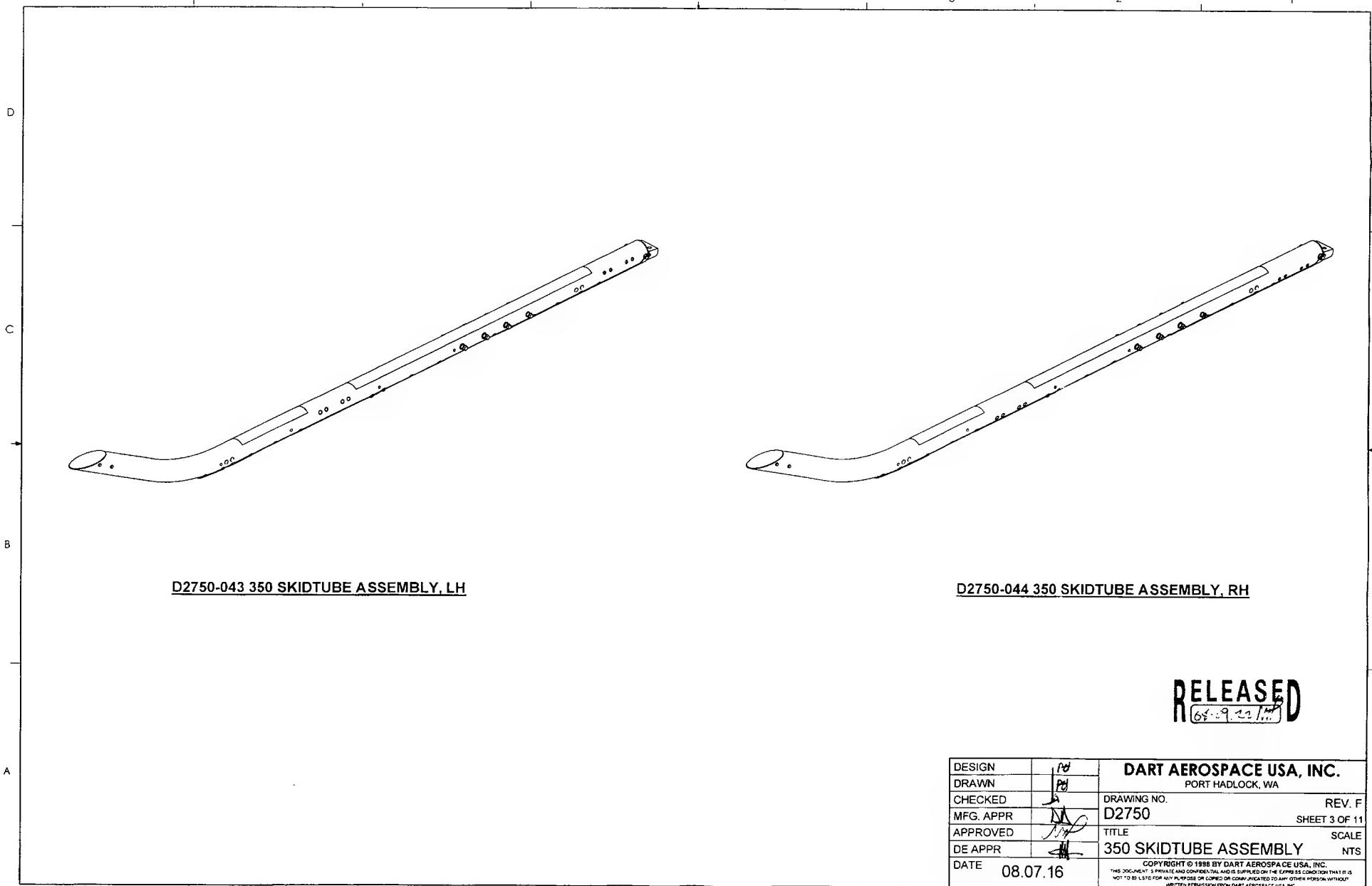
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NOTE: Date & initial all entries

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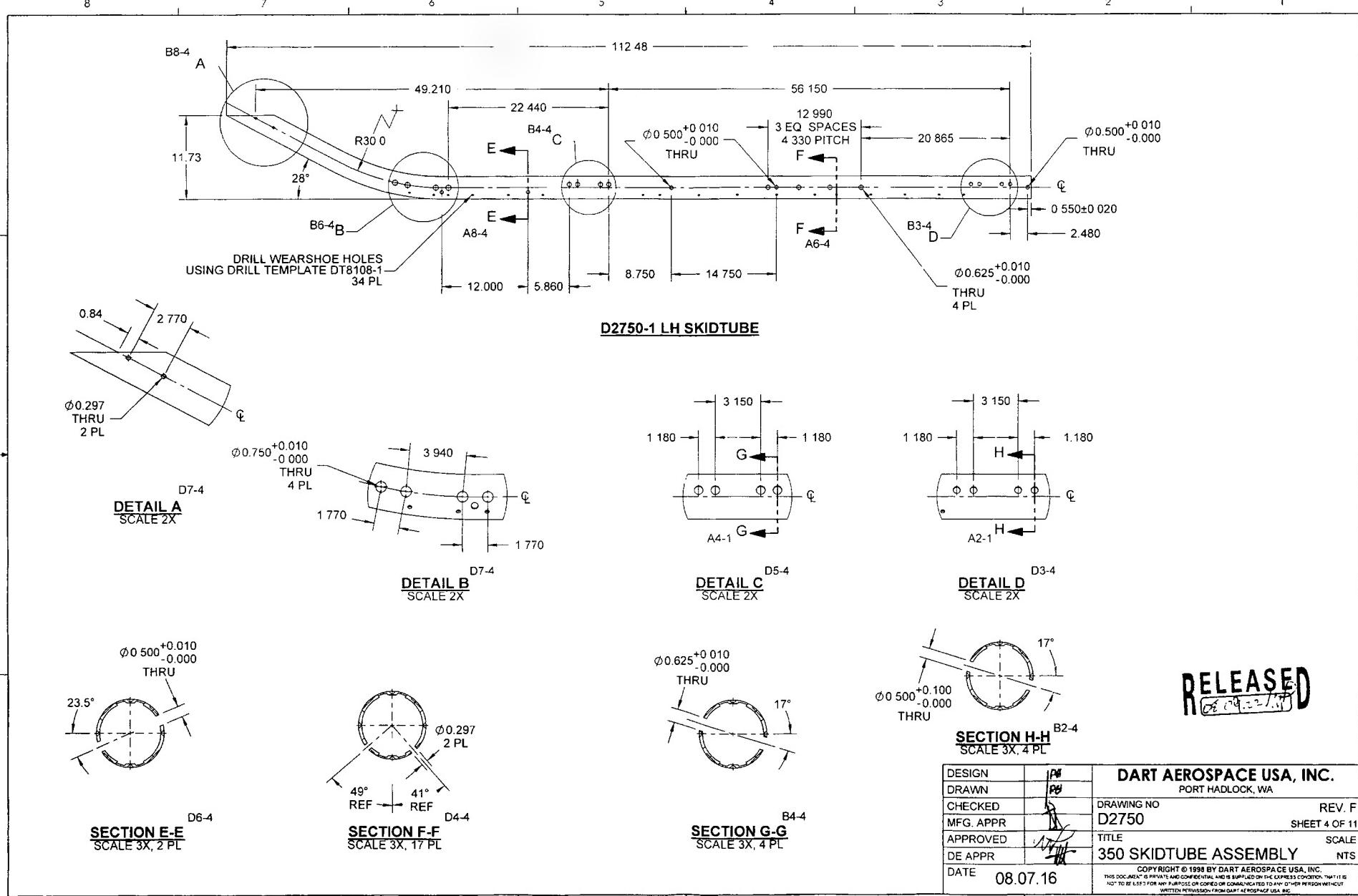


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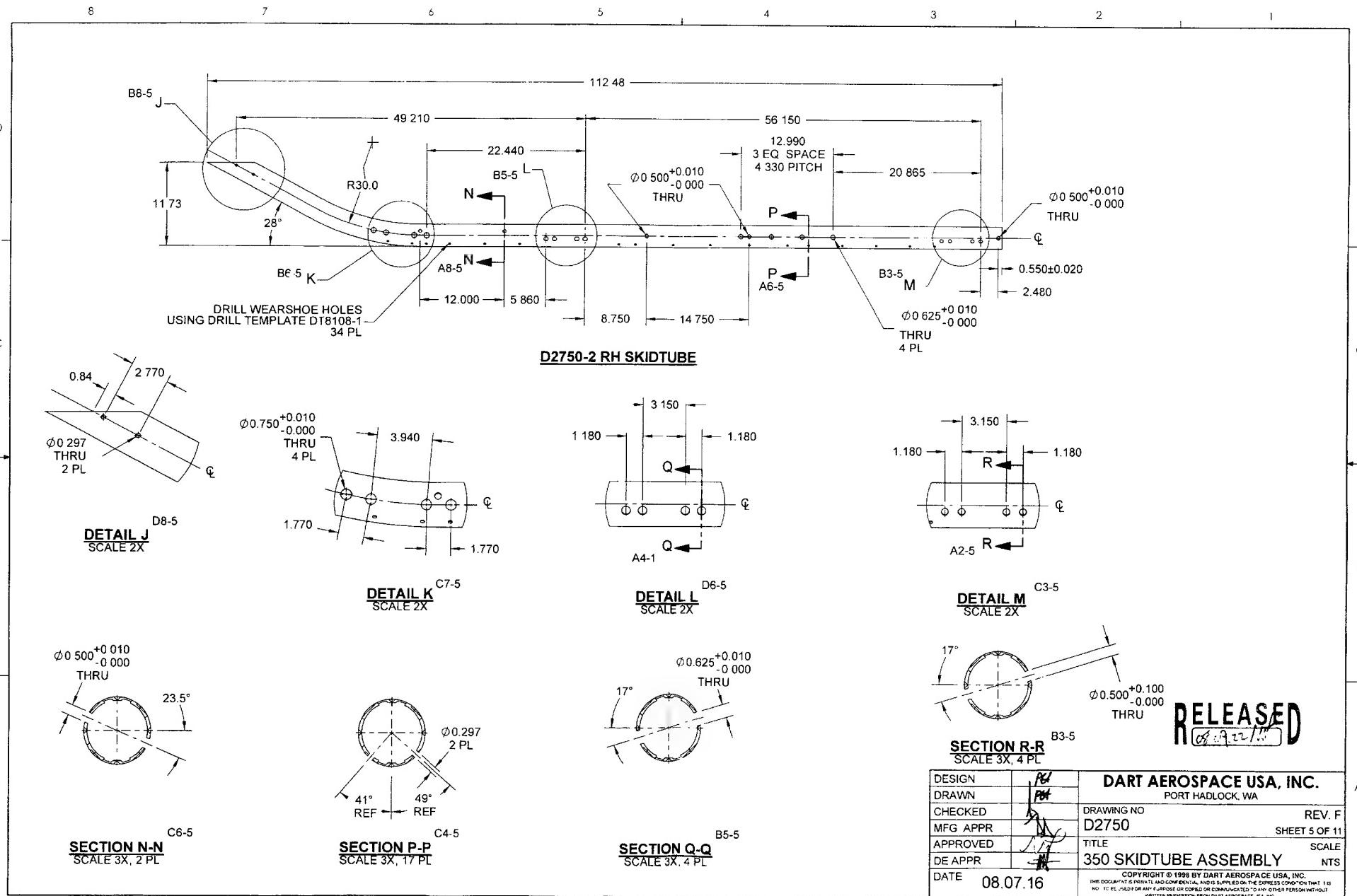


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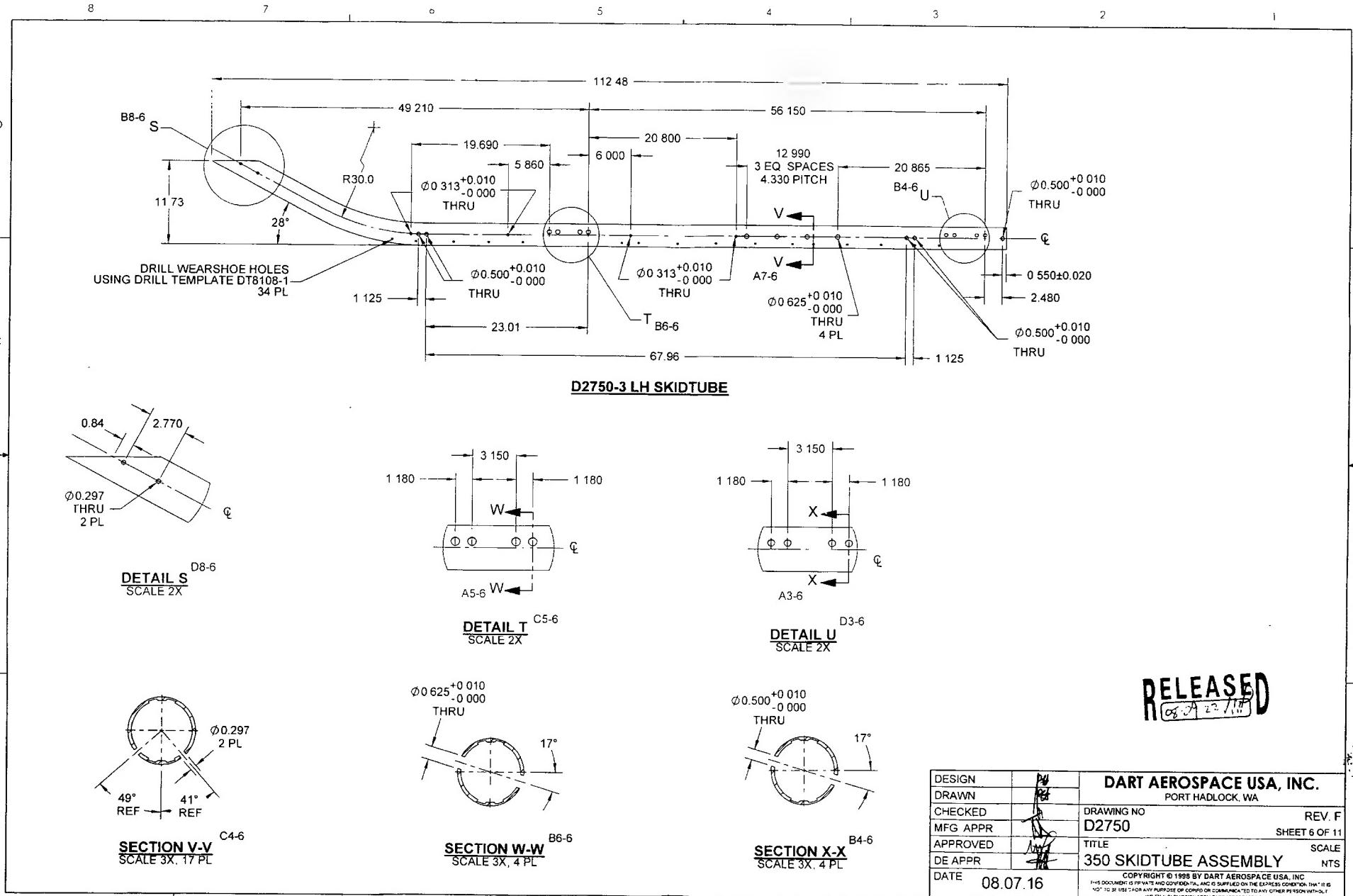
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DRAWN	<u>P&amp;I</u>	PORT HADLOCK, WA		
CHECKED	<u>SJ</u>	DRAWING NO	REV. F	
MFG APPR	<u>M</u>	D2750	SHEET 5 OF 11	
APPROVED	<u>SJ</u>	TITLE	SCALE	
DE APPR	<u>H</u>	350 SKIDTUBE ASSEMBLY	NTS	
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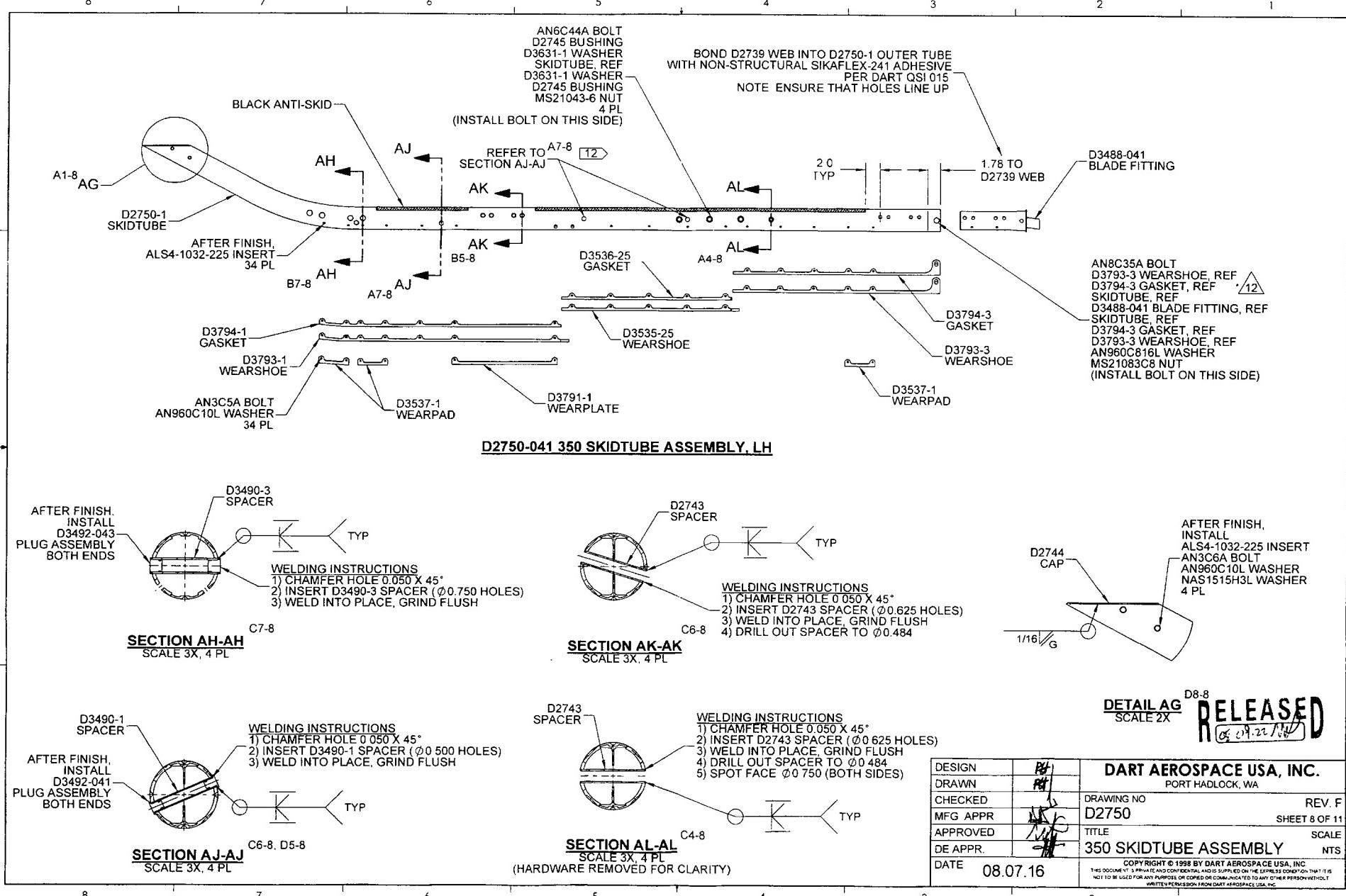
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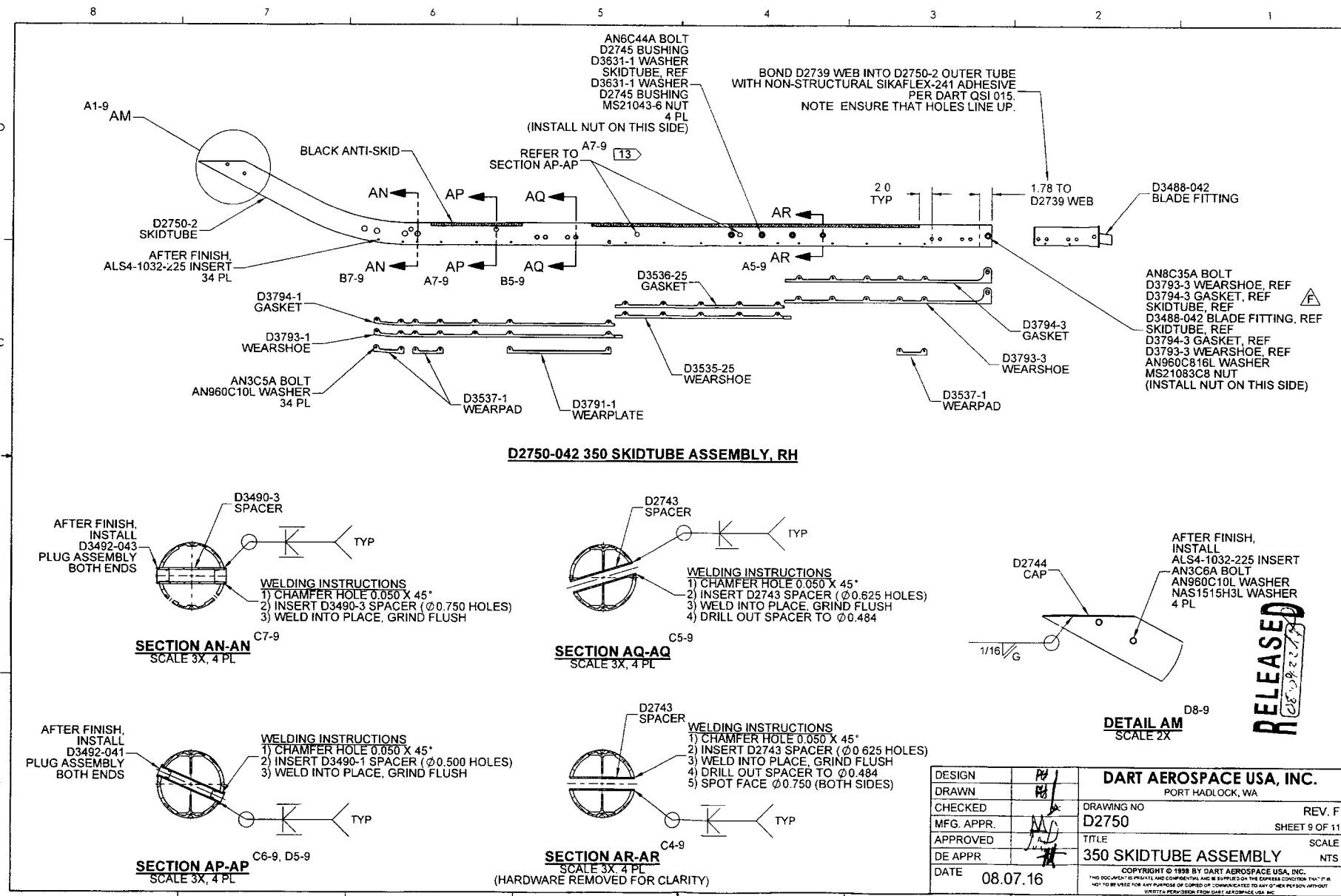


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DESIGN	PJ
DRAWN	PJ
CHECKED	
MFG. APPR.	MD
APPROVED	
DE APPR	
DATE	08.07.16

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

**DRAWING NO** D2750 **REV. F**  
**SHEET 9 OF 11**

**TITLE** 350 SKIDTUBE ASSEMBLY **SCALE** NTS

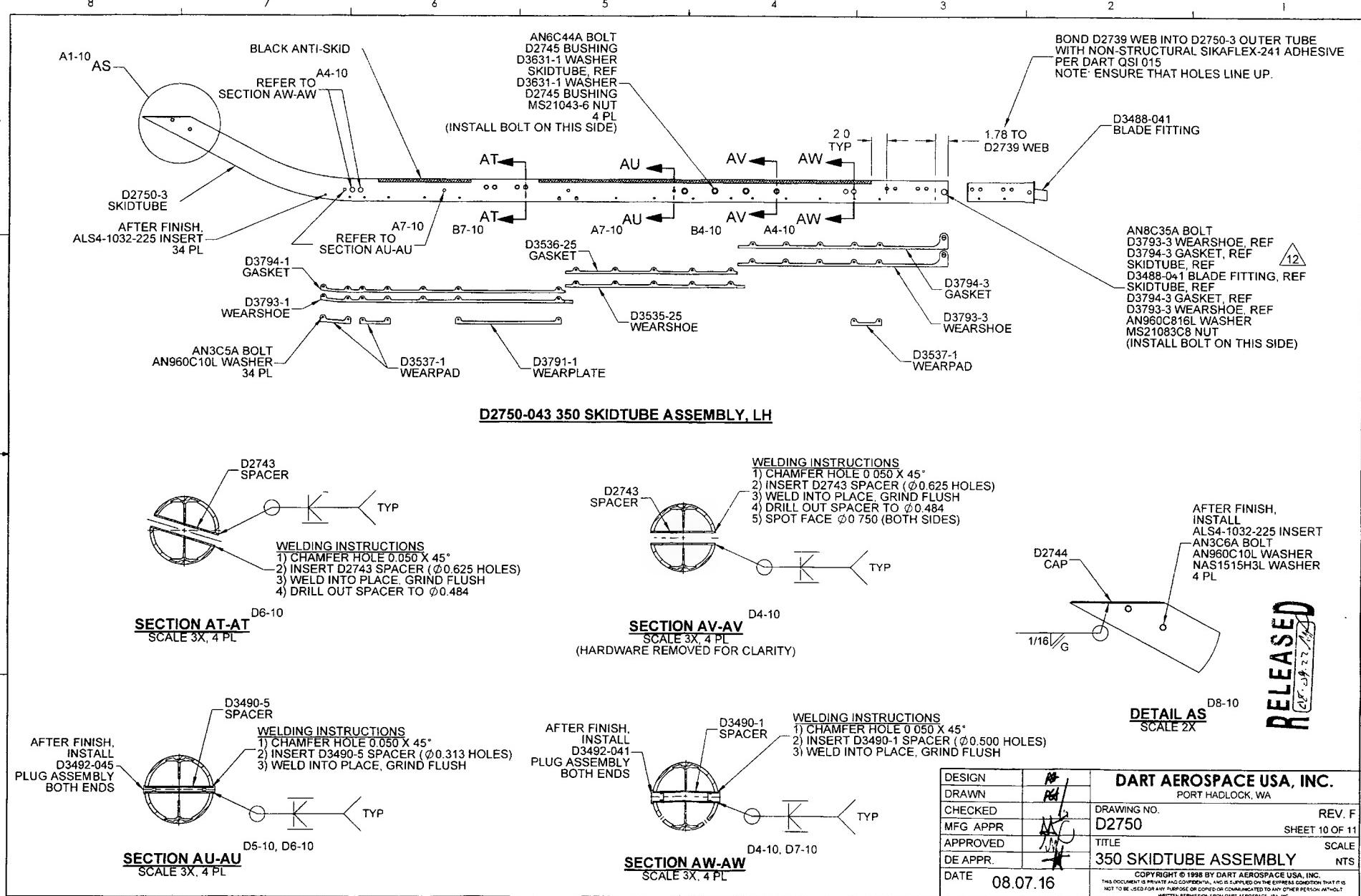
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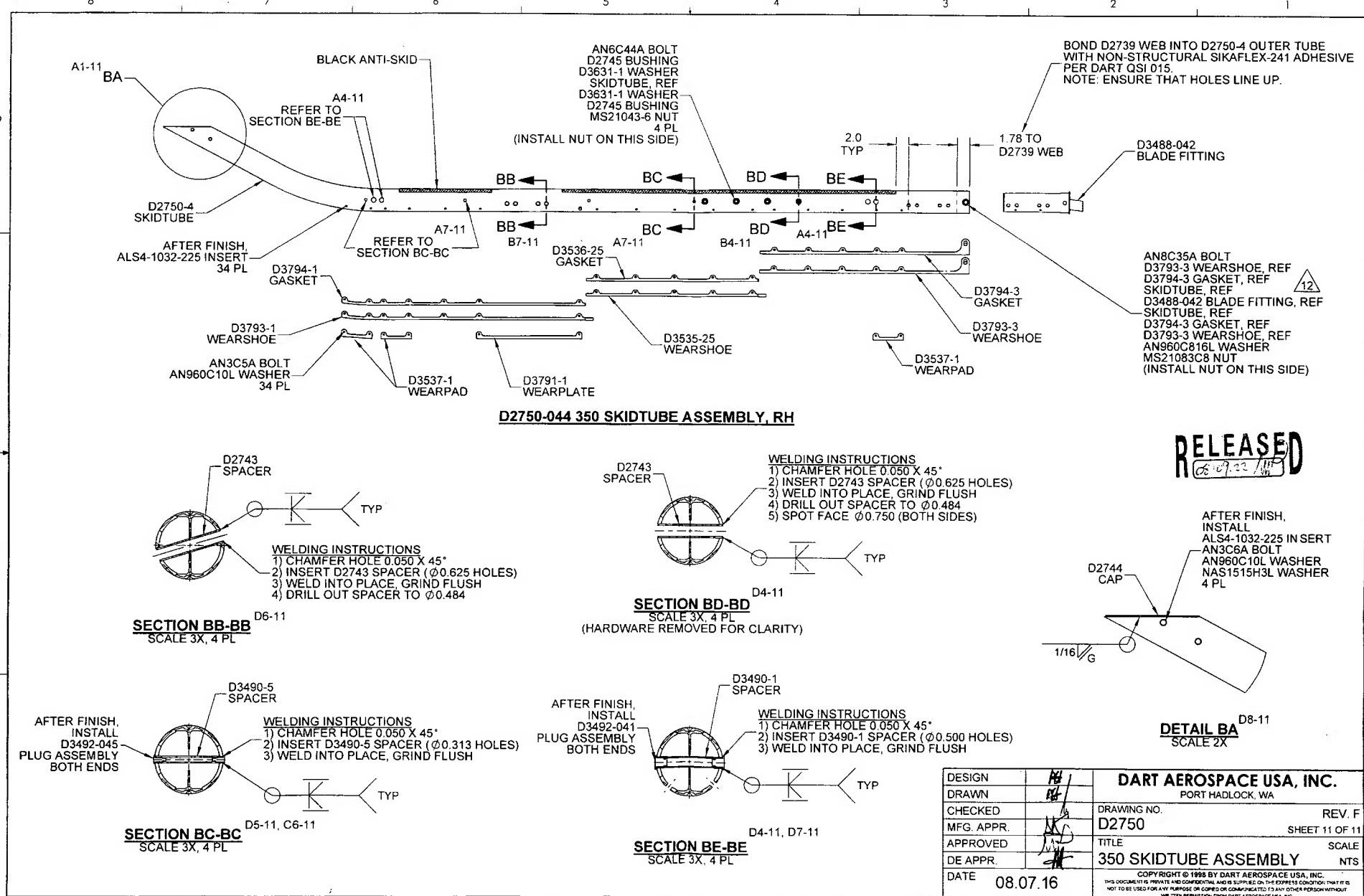


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NOTE: Date &amp; initial all entries

NO. 298

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job #: 87012  
Part #: A350-636-014  
Description: Skid tube  
Welding Process: Tig  Mig   
Base material: Aluminum  
Current: AC  DC

**TEST REQUIREMENTS AND RESULTS**

Visual:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Incomplete Penetration:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Incomplete Fusion:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Cracks:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Overlap (cold lap)	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Undercut:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Pin holes:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Porosity (surface):	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Coloration:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>
Burn through:	pass <input checked="" type="checkbox"/>	fail <input type="checkbox"/>

Qualifier Barclay Elliott Date of Test Coupon 12-07-23

Welder Barclay Elliott Date of Test Coupon 12-07-23

The above named individual is qualified in accordance with AWS D17.1.2001 to weld